



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5013370

649.5112

Job Sheet 167957



Part No: 649.5112

Job Qty: 4 ea

Part Name: RH Wiper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 11/17/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/15/17	0.00	0.00	Start Up Machining		8.3 17-11-10
100	Bandsaw	4 pcs		11/15/17	0.00	0.13	Bandsaw1		8.3 17-11-10
110	CNC Vertical Machining	4 pcs		11/17/17	0.00	27.97	HAAS 5 Axis		8.3 17-11-11
120	QC	4 pcs		11/17/17	0.00	0.00	QC2		8.3 17-11-11
130	QC	4 pcs		11/17/17	0.00	0.00	QC8		8.3 17-11-11
140	Outsource	4 pcs		11/17/17			ATG001-VC		8.3 17-11-13
150	Packaging	4 pcs		11/17/17	0.00	0.00	Packaging2		8.3 24-11-17
155	QC	4 pcs		11/17/17	0.00	0.00	QC5		8.3 24-11-17
180	Packaging	4 pcs		11/17/17	0.00	0.00	Packaging3		8.3 24-11-17
190	QC21-SA	4 Ea		11/17/17	0.00	0.00	QC21		8.3 24-11-17

Part Op 100 - Cut Blank at 7.50"

Descriptions: 110 - 1-Machine per folio Fb352 DWG REV: C FOLIO REV: 11 2- deburr and break all sharp edges

140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 649.5100 2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

2. 7 mils thickness prime

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B4.500X05.000	3	4	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/17 2:24 PM Dart.lajeunesse.marie

14.17

DQA:

Date:

WORK ORDER NON-CONFIRMANCE / UPDATE

QA Closed:

Date:

Work Order

Part

NC

Date:

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

DISPOSITION

Mfg Date: 11/10/17
 Job No: 167957

DART
 AEROSPACE

S008748



RH Wiper Deflector

PART NO:
 Revision:
 Operation:
 Change No:

649.5112

Start up Operation

DART
 AEROSPACE

S013370



RH Wiper Deflector

PART NO:
 Revision:
 Operation:
 Change No:

649.5112

Packaging

Mfg Date: 11/24/17
 Job No: 167957

PROCESS

Work Order update only

DART
 AEROSPACE

Engineering
 Quality
 Other

MRB (QS1042) Approval

Completed By

Lead hand / Supervisor
 Approval Verification

QC / QA Coordinator
 Approval

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

Fit/Function
 Misaligned/off center

Countersink
 Cut Too Short
 Instructions Incomplete/Unclear
 Drill Holes

Wavy
 Marks/Chatter

Tribal Knowledge
 LOA
 Substation
 Past Expiry Date
 Misidentified

Product Improvement
 Process Improvement
 Manufacturing Process
 Past Due

OTHER:

November 10th 2017

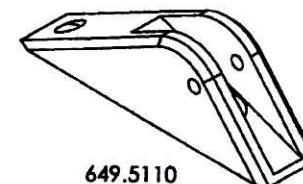
[illegible]

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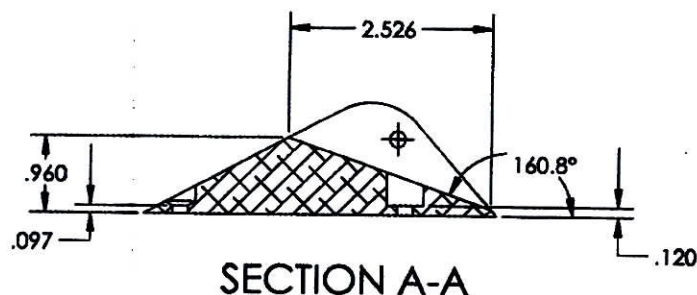
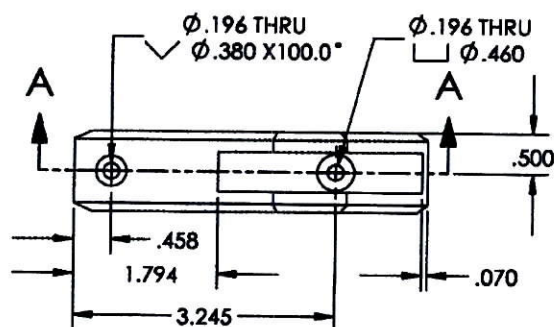
NOTES:

- 1 MATERIAL : ALUMINUM 7075-7651 PER AMS-QQ-A-250/12.
- 2 FINISH: ANODIZE AND PRIME PER MPP-172 SECTIONS 2.1 & 4.3.
- 3 PART CONTROLLED BY CAD MODEL
FILE NAME: 649.5101 WIPER DEFLECTOR.SLDPRT, LAST MODIFIED 12/07/11.
- 4 PART CONTROLLED BY CAD MODEL
FILE NAME: 649.5111 WIPER DEFLECTOR.SLDPART, LAST MODIFIED 10/26/17.
- 5 PART CONTROLLED BY CAD MODEL
FILE NAME: 649.5111 WIPER DEFLECTOR.SLDPART, LAST MODIFIED 10/26/17.
- 6 DEBURR AND BREAKD ALL SHARP EDGES.
- 7 IDENTIFY IAW MPP-120. LASER ETCH P/N REVISION, 12 PT. CENTURY GOTHIC.

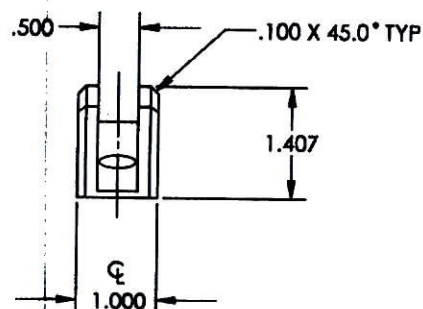
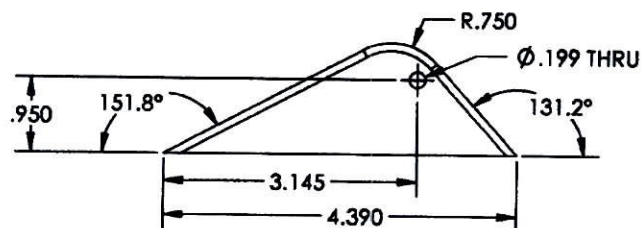
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
NC	INITIAL RELEASE	12-07-11	P. BRAVO
A	INCORPORATED ECH 03071	04-11-12	P. BRAVO
B	INCORPORATED ECH 03085, 03086	08-26-17	P. BRAVO
C	INCORPORATED ECH 03087	10-26-17	P. BRAVO



649.5110



SECTION A-A



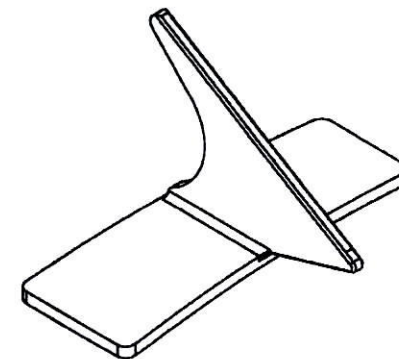
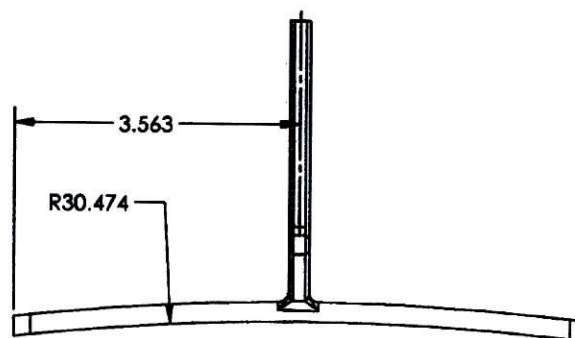
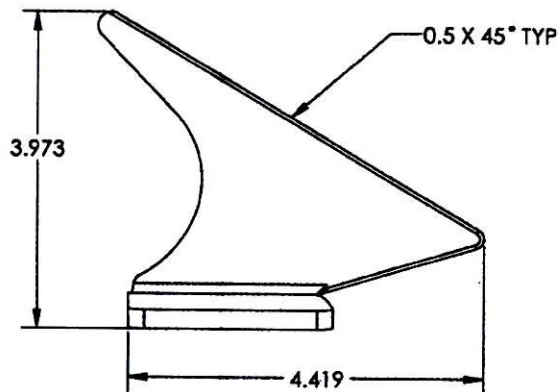
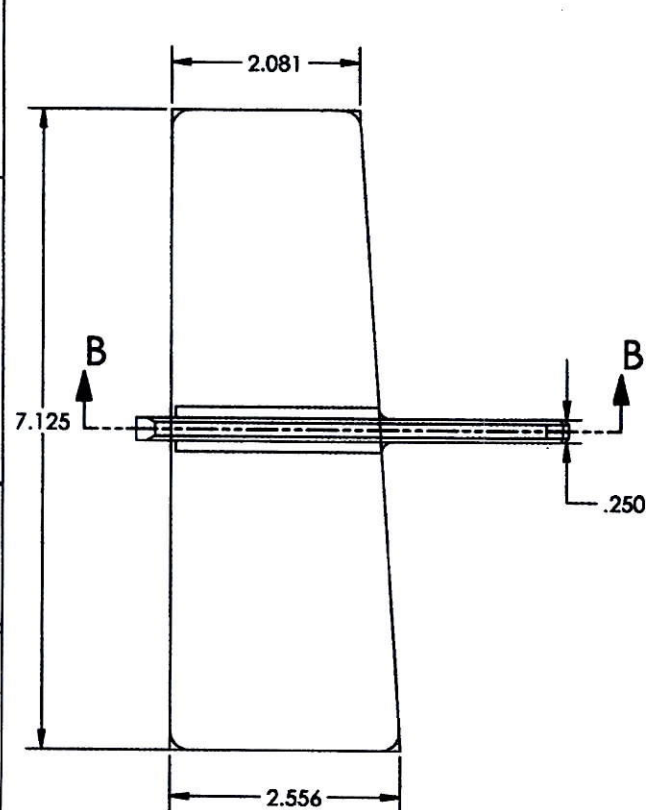
QTY	3	2	1
PART #	649.5112	649.5111	649.5110
DESCRIPTION	RH WIPER DEFLECTOR	LH WIPER DEFLECTOR	WIPER DEFLECTOR
MATL			
SPEC.			

ORIGINAL DATE 12-07-11	DESIGNER A. GIBAN	DATE 12-07-11
DRAWING APPROVAL P. BRAVO	CHECKED P. BRAVO	
CONTRACT NO.		

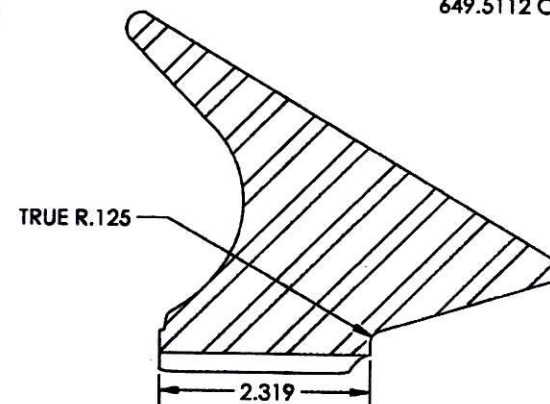
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS .001 2 PLACE DECIMALS .0005 ANGLES .5°	DART AEROSPACE 3000 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300 WWW.DARTAEROSPACE.COM
--	--

REV	8	07/26	DWG. NO.	649.5100	REV.	C
SCALE	NONE				SHEET	1 OF 2

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649.5111 SHOWN
649.5112 OPPOSITE



SECTION B-B

ORIGINAL DATE 10-04-11		3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (760)-724-5300	
DRAWN BY A. QUAH		P. BRAVO	
DRAWING APPROVAL P. BRAVO		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		WIPER DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.2°		REV. B 07M26	649.5100 C
SCALE NONE		SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038349

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Laiande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038349
PO Date: 11/14/17
Due Date: 11/17/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167956	649.5111	-	LH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 HARD BLACK ANODIZE/PRIME		Firmed	11/17/17	4 pcs	0 pcs	4 pcs	\$18.30/pcs	\$73.20
Line Item Note RUSH!!!!												
2	167957	649.5112	-	RH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 HARD BLACK ANODIZE/PRIME		Firmed	11/17/17	4 pcs	0 pcs	4 pcs	\$18.30/pcs	\$73.20
Line Item Note RUSH!!!!												
3	167199	646.9910	-	Struts Issue P/O to ATG : AS PER DWG 646.9900 HARD ANODIZE BLACK/PRIME		Firmed	11/17/17	55 pcs	0 pcs	55 pcs	\$15.40/pcs	\$847.00
4	166552	D4703-043	-	Lock Pin Base Issue P/O to ATG: As Per Dwg D4703 BLACK ANODIZE		Firmed	11/17/17	2 pcs	0 pcs	2 pcs	\$9.35/pcs	\$18.70
5	166817	D4824-1	-	Upper Cutter Mount Issue P/O: AS PER DWG D4824 HARD BLACK AMNODIZE/PRIME		Firmed	11/17/17	10 pcs	0 pcs	10 pcs	\$15.40/pcs	\$154.00
6	167390	RBEM210V4000103-3	-	Bolt -Issue P/O to ATG: AS PER DWG RBEM210V4000103 -ANODIZE COLOR CLEAR		Firmed	11/17/17	2 pcs	0 pcs	2 pcs	\$9.35/pcs	\$18.70
7	166865	649.4816	-	Doubler ISSUE P/O: AS PER DWG 649.4800 HARD BLACK ANODIZE/PRIME		Firmed	11/17/17	20 pcs	0 pcs	20 pcs	\$32.00/pcs	\$640.00
8	166658	646.3610	-			Firmed	11/17/17	10 pcs	0 pcs	10 pcs	\$8.60/pcs	\$86.00



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914138

Date: 17-Nov-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
4 ea	Part: 649.5111 LH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21967	PO: PO038349	Rev: C Line: 1
4 ea	Part: 649.5112 ✓ RH Wiper Deflector Job: 21968	PO: PO038349	Rev: C Line: 2 <i>SPD 11-24</i>
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>12/11/17</u> Certified Signature: <u><i>[Signature]</i></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			



Dart Hawkesbury
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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M7075T6B4.500X05.000 Revision: 7075-T6 Bar 4.5" X 5"														
100	Receive Ft	S008745	167957	0 ft	0	M133453	Start Up Machining		WIP	11/10/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		1		0	0									

Plex 1/8/2018 9:56 AM Dart.Boucher.Sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						